

Work Order ID 131225

March-31-15 8:08:08 AM

131225

Page 1

Item ID: D4965-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Step Spacer

Stop

NS2

Start Date: 3/31/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/06/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4965

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr as required

2

02/15/03/31

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

2

02/15/03/31

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Page 2

Item ID: D4965-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Spacer
Start Date: 3/31/15 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 4/06/15 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(2)			DAS 38 9-89 APR 01 2015
130 *130* Brake NC Brake NC	Bend as per dwg Memo FORM FLANGE AS PER DWG USING DT8174	0.00 0.00			DAS 30 9-89	2			15/04/01
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(2)			DAS 38 9-89 APR 01 2015

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Item ID: D4965-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Spacer
 Start Date: 3/31/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 4/06/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>G-1</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									

2 13-4-15

2x 15/04/02 DAS 36 9-89

2x 15/04/02 DAS 36 9-89

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Item ID: D4965-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Spacer
Start Date: 3/31/15 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 4/06/15 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	QC21- Final Inspection - Work Order Release	0.00							
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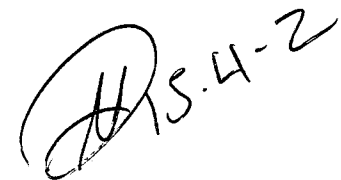
190

QC

Memo

0.00

Quality Control

ML5 1504-02

Picklist Print

March-31-15 8:08:08 AM

Page 1

Work Order ID: 131225

131225

Parent Item: D4965-3

D4965-3

Parent Item Name: Step Spacer

Start Date: 3/31/15

Required Date: 4/06/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.11.05 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased		No			sf	80.5882		1			

M2024T3S 040

2024-T3 .040 sheet

**

DL15/03/2015

Location

Loc Qty

Loc Code

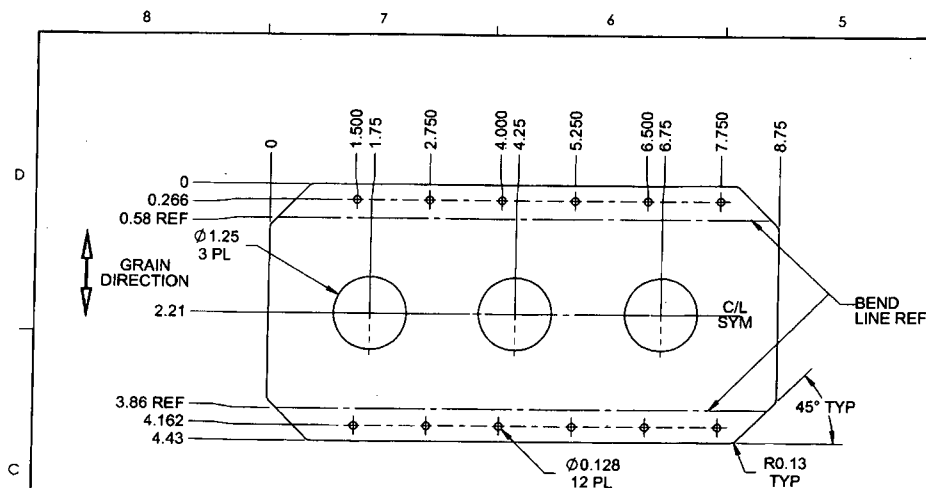
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80.5882

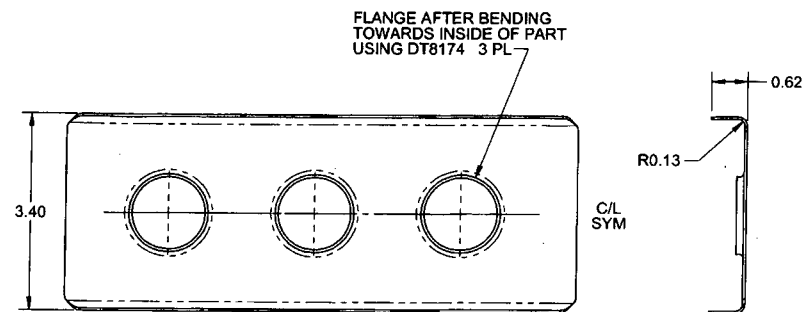
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80.5882

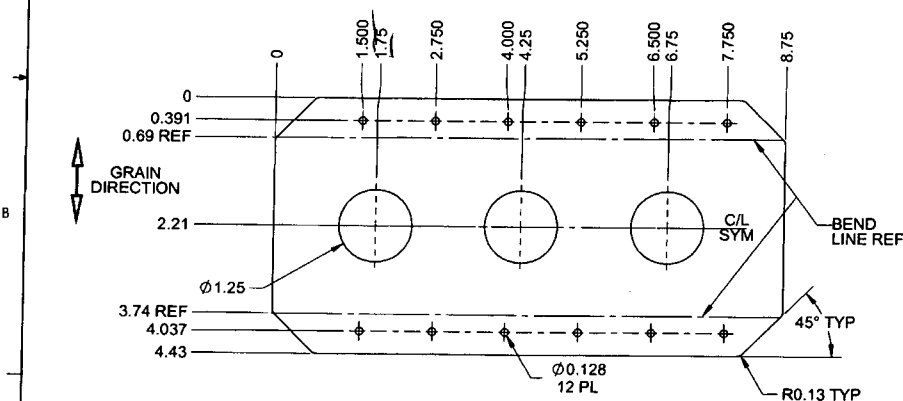
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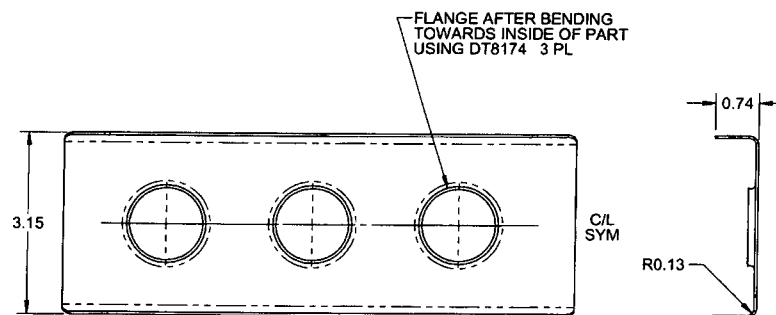
D4965-1F FLAT PATTERN



D4965-1 STEP SPACER



D4965-3F FLAT PATTERN



D4965-3 STEP SPACER

NOTES:

- 1) MATERIAL: D4965-1: MAKE FROM D4965-1F
D4965-3: MAKE FROM D4965-3F
D4965-1F/3F: 2024-T3 ALUMINIUM SHEET 0.040" THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR ASTM B209
(REF DART SPEC M2024T3S.040)
- 2) FINISH: D4965-1/-3: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4965-1/-3: 0.14 lbs
- 8) ALL NON DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D4965-1F_REV A.DXF" AND "D4965-3F_REV A.DXF"

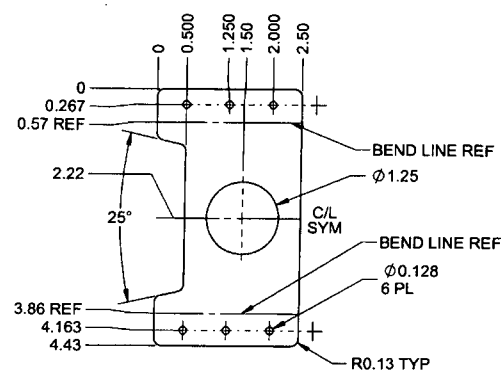
A		NEW ISSUE		DB	13.10.24
REV.	DESCRIPTION			BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	DB				
CHECKED	MB	DRAWING NO.	REV. A		
MFG. APPR.	DD	D4965	SHEET 1 OF 2		
APPROVED	MP	TITLE	SCALE		
DE APPR.	DS	STEP SPACER	NTS		
DATE	13.12.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
2014-01-07

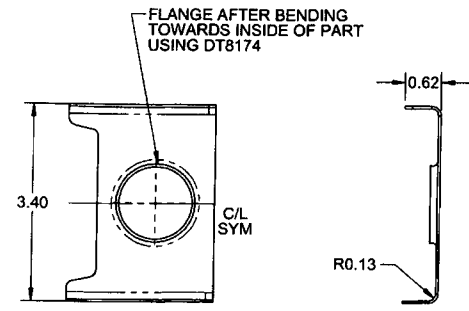
WLO 131225

8 7 6 5 4 3 2 1

GRAIN
DIRECTION

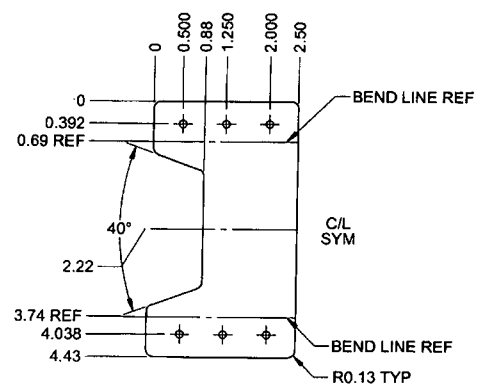


D4965-5F FLAT PATTERN

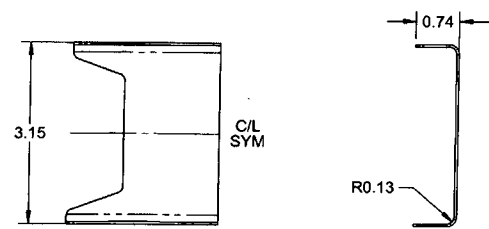


D4965-5 STEP SPACER

GRAIN
DIRECTION



D4965-7F FLAT PATTERN



D4965-7 STEP SPACER

NOTES:

- 1) MATERIAL: D4965-5: MAKE FROM D4965-5F
D4965-7: MAKE FROM D4965-7F
D4965-5F/-7F: 2024-T3 ALUMINIUM SHEET 0.040" THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: D4965-5/-7: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4965-5/-7: 0.01 lbs
- 8) ALL NON DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D4965-5F_REV A.DXF" AND "D4965-7F_REV A.DXF"

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. A
MFG. APPR.	DD	D4965	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	STEP SPACER	NTS
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RELEASED
2014-01-07

8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order:	131225
Description: Step Spacer		Part Number:	4965-3
Inspection Dwg: 4965 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .128	-.001 +.005	Ø .127	/			
Ø 1.25	-.001 +.002	1.249	/			
1.500	+/- .010	1.501	/			
1.75	+/- .030	1.751	/			
2.750	+/- .010	2.753	/			
4.000	+/- .010	4.001	/			
4.25	+/- .030	4.252	/			
5.250	+/- .010	5.248	/			
6.500	+/- .010	6.503	/			
6.75	+/- .030	6.751	/			
7.750	+/- .010	7.752	/			
8.75	+/- .030	8.753	/			
.391	+/- .010 .005	.395	/			
2.21	+/- .030	2.215	/			
4.037	+/- .010	4.041	/			
4.43	+/- .030	4.432	/			

Measured by:	<i>DR</i>	Audited by:	DAS 38 9-89	Preliminary Approval:	
Date:	15/03/31	Date:	APR 01 2015	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	